

**Work Order ID 70489**

Thursday, June 09, 2011 3:18:57 PM

Page 1

Item ID: D206-642-151 *left HAND*

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 6/9/2011 Start Qty: 1.00

Required Date: 6/20/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *H*Date: *6-9*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

N

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile &amp; type labels per PPP. D206-642-151

CHG001

*N/A*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Setup Start

Revision ID:

Stop

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Start Date: 6/9/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ M112860/M115778 BE 11/08/19

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

3 DL 11/07/07

BE 11/08/19

BE 11/08/26

Dart Aerospace Ltd

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Run Start

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.  
\*\*\*\*no wearplate holes for this skidtube\*\*\*\*

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

S 11/09/29

BE 11/09/24

Dart Aerospace Ltd

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				(x1)	Ø		
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								
160	Skidtubes	0.00							
	Skidtubes	0.00							
	Skidtubes								
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

Ac 11.08.29

(x1)

Ø

1

Ø

BE 11/09/08

1

Ø

BE 11/09/08

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC6- Inspect dimensions to drawing

0.00

*E uloz/09*



QC

Memo

0.00

Quality Control

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond *D2654-1* web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: *11/09/15* Time: *9:00*

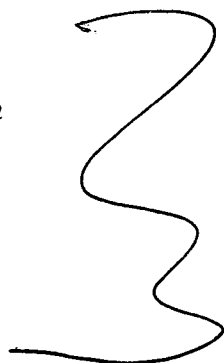
Finish Date: *11/09/15* Time: *9:00*

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 *118291* ☐

Sikaflex expire date: *12/01/05*



*BE 11/09/15*

Dart Aerospace Ltd

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/21/16

(70)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

\_\_\_\_\_

Page 7

**Accept**

\_\_\_\_\_

**Setup Start**

\_\_\_\_\_

**Stop**

**00000000000000000000000000000000**

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching the problem, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy to solve the problem. This involves breaking down the problem into smaller, manageable parts and determining the best approach to tackle each part.

4. The fourth step is to implement the plan. This involves carrying out the tasks and actions outlined in the plan, while monitoring progress and making adjustments as needed.

5. The fifth step is to evaluate the results. This involves assessing the effectiveness of the solution, identifying any areas for improvement, and documenting the findings.

**Customer:**

**Required Date:** 6/20/2011      **Req'd Qty:** 1.00

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

[illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

## Operation Description

## Set Up/ Run Hours

## Tool ID

**Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

200

0.00



## Skidtubes

## Skidtubes

## Skidtubes

## Memo

0.00

1-remove alodine from around hole and prepare for welding

BEA/09/9

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

[illegible]

A/R ☐ Aluminum Rod ☒ *m112860*

" before welding the  
 BE 11/09/19

3-Grind welds flush as per Dwg D3804.

Dh. 11/09/19

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

NONE BE 11/09/21

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

11-9-21

**Dart Aerospace Ltd**

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# Work Order ID 70489

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Item ID: D206-642-151

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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

xl

Oh

11/09/27

220

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.09.28

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Smokes

Smokes

**Dart Aerospace Ltd**

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-9-29

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00  
320 OF  
12:30

1X of M-L 11/04/29

260

QC3- Inspert Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of M 11/01/03

**Dart Aerospace Ltd**

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Plan  
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QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-291 ☐ M118903Sikaflex expire date: ☐ 12/10/11

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M118903

**Dart Aerospace Ltd**

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Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

290

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

PPP 74408

SP 11-10-20

**Dart Aerospace Ltd**

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Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/20  
mf  
11-10-20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 09, 2011 3:19:03 PM

Page 1

Work Order ID: 70489

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube







Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
D2620  Skidtube, 206 Skidtube		Manufactured	No				Each	12.0000		1																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>LG 371416</td><td>12</td><td></td></tr><tr><td>62684</td><td>1</td><td></td></tr><tr><td>68135</td><td>1</td><td></td></tr><tr><td>68136</td><td>10</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	LG 371416	12		62684	1		68135	1		68136	10	
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
LG 371416	12																											
62684	1																											
68135	1																											
68136	10																											
D3286-1  Doubler		Manufactured	No				Each	36.0000		2																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>LG002</td><td>36</td><td></td></tr><tr><td>52844</td><td>15</td><td></td></tr><tr><td>64563</td><td>21</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	LG002	36		52844	15		64563	21				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
LG002	36																											
52844	15																											
64563	21																											
D2647  Cap		Manufactured	No				Each	30.0000		1																		
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>LG002</td><td>30</td><td></td></tr><tr><td>55352</td><td>30</td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	LG002	30		55352	30							
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																										
LG002	30																											
55352	30																											

11/07/07

8611/03/16

8611/08/19

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

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Thursday, June 09, 2011 3:19:03 PM

Page 2

Work Order ID: 70489

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

Each

678.0000

52



Cherry Rivet

BE 11/09/15

Location

Loc Qty

Loc Code

ST311

678

115698

39

116471

139

117816

500

52

D2654-1

Manufactured

No

Each

0.0000

1



Web

D2649

Manufactured

No

Each

207.0000

19



Cross Bolt Spacer

BE 11/09/15  
B 64562

BE 11/09/19  
B 73390

Location

Loc Qty

Loc Code

LG

195

68224

40

70394

155

LG001

12

65317

1

68507

11

2

D3286-3

Manufactured

No

Each

31.0000



Spacer

BE 11/09/11

Location

Loc Qty

Loc Code

LG002

31

46643

1

64564

30

2

Thursday, June 09, 2011 3:19:04 PM

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Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, June 09, 2011 3:19:04 PM

Page 3

Work Order ID: 70489

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

581.0000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

579

117086

79

117849

500

CR3212-4-03

Purchased

No

Each

1,228.000

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1226

114859

1226

D2680-041

Manufactured

No

Each

36.0000

1



Nut Plate

Location

Loc Qty

Loc Code

ST020

36

55366

17

70088

19

D3805-041

Manufactured

No

Each

2.0000

1



Wearplate Assembly Fwd, Low Gear

Location

Loc Qty

Loc Code

FP

2

64565

2

B73813

Thursday, June 09, 2011 3:19:04 PM

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Page 3

**Dart Aerospace Ltd**

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Work Order ID: 70489



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3805-045 Manufactured No

Each 2.0000



1

Handwritten: 11/10/05

Wearplate Assembly Aft, Low Gear

Location

Loc Qty

Loc Code

FP

2

1370878

64566

2

Handwritten: 11/10/05

AN3-37A Purchased No

Each 255.0000



7

Handwritten: 11/10/03

Bolt

Location

Loc Qty

Loc Code

ST353

205

105425

69

111668

136

Handwritten: 11/10/03

ST354

50

117619

50

AN960JD10 NAS1149D03631 Purchased No

Each 0.0000



7

Handwritten: 11/10/03

Washer

MS21042L3 Purchased No

Each 2,322.000



7

Handwritten: 11/10/03

Nut

Location

Loc Qty

Loc Code

ST300

2322

116391

9

116549

613

117441

800

117601

400

117885

500

Handwritten: 11/10/03

Handwritten: 11/10/03

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Thursday, June 09, 2011 3:19:04 PM

Page 5

Work Order ID: 70489



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

Each 112.0000

14



14

11/10/03

Bushing

Location

Loc Qty

Loc Code

ST084

100

B71837

14

68247

100

ST088

12

64760

12

AN960JD416 NAS1149D0463J Purchased No

Each 0.0000

1



1118384



(x1) 14

11/10/03

Washer

D2651-1 Manufactured No

Each 248.0000

6



6

11/10/03

Plug

Location

Loc Qty

Loc Code

fpa

121

69018

121

FP-A

127

57869

7

66445

10

67263

12

67760

98

D2651-3 Manufactured No

Each 576.0000

6



6

11/10/03

O-Ring

Location

Loc Qty

Loc Code

FP-A

576

61962

132

66956

444

14

Thursday, June 09, 2011 3:19:05 PM

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Page 5

**Dart Aerospace Ltd**

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Thursday, June 09, 2011 3:19:05 PM

Page 6

Work Order ID: 70489

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011

Required Date: 6/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

Each

61.0000

1



11/10/03

Screw

Location

Loc Qty

Loc Code

EP-A

26

115460

26

ST292

35

115460

35

D2646

Manufactured

No

Each

24.0000

1



11/10/03

Aft Cap

Location

Loc Qty

Loc Code

FP006

23

62678

23

FP-4

1

69019

1

MS27039-1-08

Purchased

No

Each

768.0000

2



11/10/03

Screw

Location

Loc Qty

Loc Code

ST291

768

115108

468

117423

300

AN960JD10L

NAS1149D0332J

Purchased

No

Each

0.0000

2



(x2) 11/10/03

Washer

11/17/08

Thursday, June 09, 2011 3:19:05 PM

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Page 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70489  
011-06-9

RELEASED  
09.03.03  
per ECN 09-530

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	93	DART AEROSPACE USA, INC	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	93	DRAWING NO.	REV. A
MFG. APPR.	BE	D3804	SHEET 1 OF 5
APPROVED	93	TITLE	SCALE
DE APPR.	93	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**Dart Aerospace Ltd**

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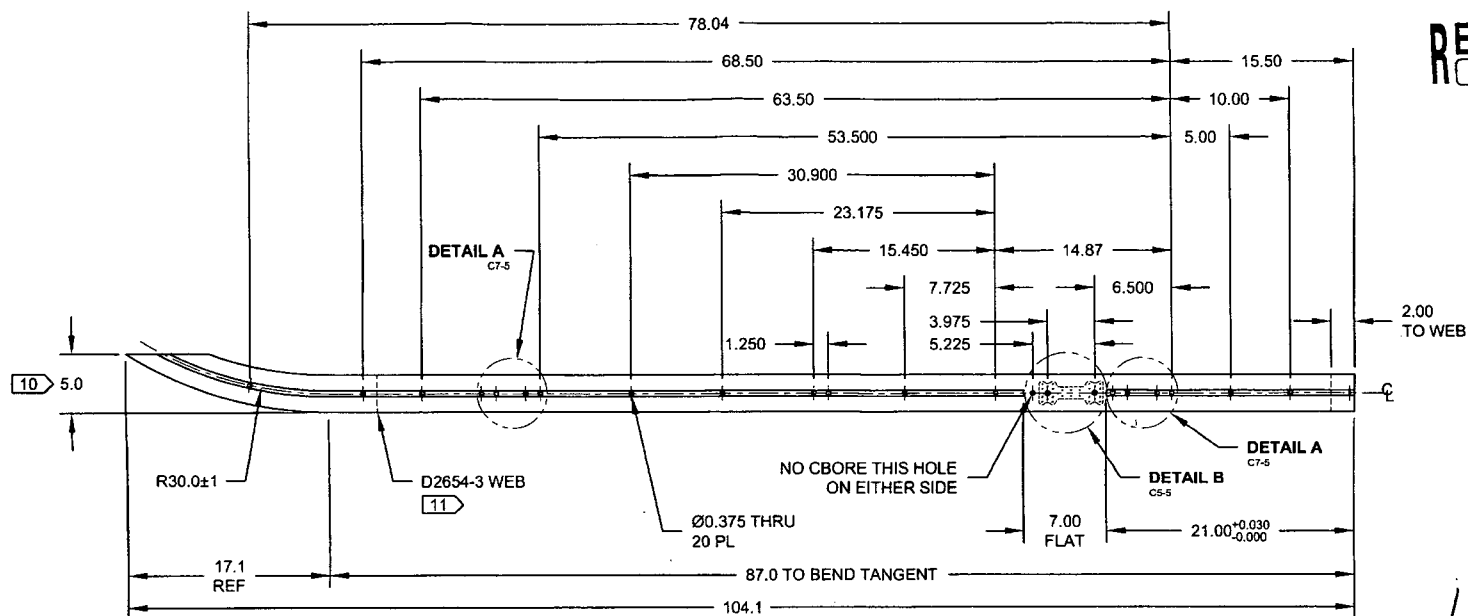
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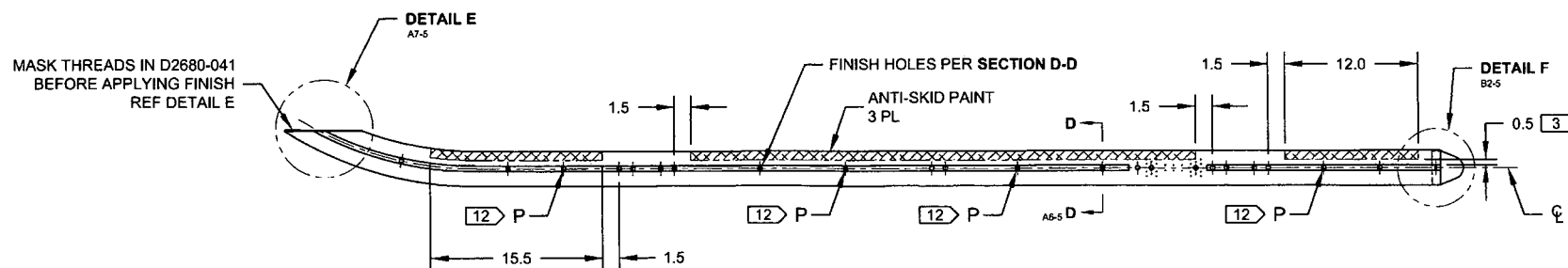
**NOTE:** Date & initial all entries



RELEASED  
09-03-03



**D3804-043 BENDING/DRILLING DETAIL**



**D3804-043 ASSEMBLY/FINISHING DETAIL**

DESIGN	97	<b>DART AEROSPACE USA, INC</b>	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 3 OF 5
APPROVED	J	TITLE	SCALE
DE APPR.	J	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

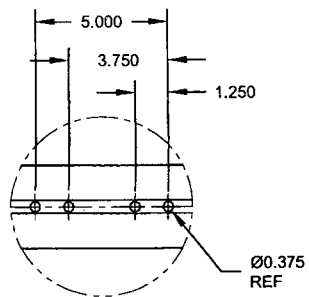
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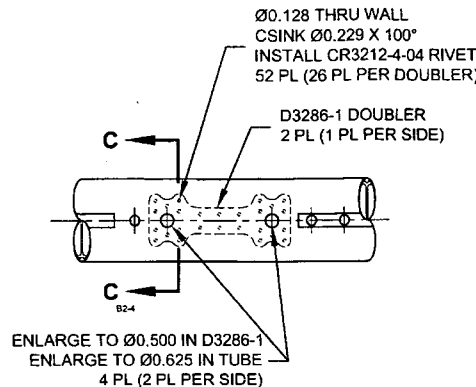
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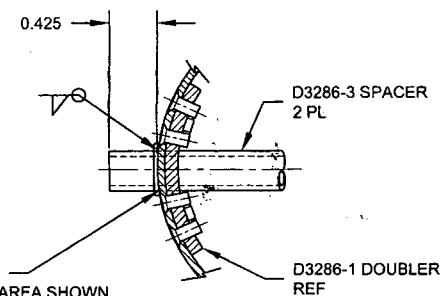
**RELEASED**  
UP 09.03.07



**DETAIL A** D6-2  
SCALE NONE C2-2  
D6-3  
C2-3

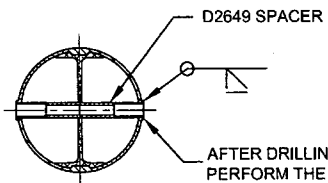


**DETAIL B** C3-2  
SCALE NONE C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C** C6-4  
PARTIAL SECTION  
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

**SECTION D-D** A4-2  
FOR Ø0.375 HOLES ONLY A4-3  
SCALE NONE

W/O 170489

DESIGN	99	<b>DART AEROSPACE USA, INC</b>	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 4 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
09 03 03

CCR264SS3-3  
RIVET  
2 PL

CR3212-4-03 RIVET  
2 PL

**VIEW G-G**  
SCALE NONE A7-5

D2647 CAP, TO INSTALL:  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS REQD)  
4. WELD D2647 IN PLACE  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE  
IN PLACE

MS27039-4-06 SCREW  
AN960JD416 WASHER

D2680-041  
NUTPLATE

1.0 REMOVE RIDGE ON  
INSIDE OF SKIDTUBE  
LEAVE 0.070 MIN.

**DETAIL E**  
SCALE NONE B7-2  
B7-3

0.400

END OF WEB

SEAL WITH  
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204  
REF

MS27039-1-08 SCREW  
AN960JD10L WASHER  
2 PL

BORE OUT END  
OF SKIDTUBE  
TO 0.75 DEPTH  
AND 0.070 WALL

**DETAIL F**  
SCALE NONE B2-2  
B2-3

216 70459

DESIGN	47	<b>DART AEROSPACE USA, INC</b>	
DRAWN	47	PORT HADLOCK, WA	
CHECKED	47	DRAWING NO.	REV. A
MFG. APPR.	47	D3804	SHEET 5 OF 5
APPROVED	47	TITLE	SCALE
DE APPR.	47	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 266

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 704089  
Part number: 3206 642 151  
Description: 206  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier John Davis Date of Test Coupon 11-09-22

Welder Barclay Elliott Date of Test Coupon 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld